

Work Order ID 64611



Page 1

Thursday, December 09, 2010 10:18:59 AM

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/12/09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

Left hand.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Debur Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Debur

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-5-3

BE 11/05/04

BE 11/05/04

11-5-4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00

Memo

8/11/10/06



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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

~~1- Open crossbolt holes to Ø0.3125"~~~~2- Open Air cap hole #6.~~~~****no wearplate holes for this skidtube****~~

3-Debur tube and blow out chips from inside the tube

*Move to seq 110
11.05.06*

140

0.00



Chemical Conversion Coat per QS1005 4.1

HandFinish

Memo

0.00

Hand Finishing

B 11/05/10

150

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

DP 11-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								
170 QC	QC6- Inspect dimensions to drawing	0.00							
Quality Control	Memo	0.00							

11.05.10

DP 11-5-10

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☐ 11-5-17 Time: ☐ 11:00 ☐Finish Date: ☐ 11-5-17 Time: ☐ 9:30am

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Sikaflex-291 ☐ M116948 ☐Sikaflex expire date: ☐ 12-1-15

AA 11.05.10

DP 11-5-17

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/10

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00				1	0	0	
Skidtubes	Memo	0.00							
Skidtubes	1-remove alodine from around hole and prepare for welding								
	2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.								
	Pick: Qty <input type="checkbox"/> Part Number <input type="checkbox"/> Description <input type="checkbox"/> Batch A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> M111385								
	3-Grind welds flush as per Dwg D3804.								
	4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.								
	A/R <input type="checkbox"/> SS Rod <input checked="" type="checkbox"/> NONE								
	5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr								

BE 11/05/19

BE 11/05/19

BB 11/05/19

BE 11/05/26

BE 11/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

1

B11/05/26

220

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

8/16/27

Pto ->

230

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/16/27

W/O: 64611		WORK ORDER CHANGES						
DATE	STEP	Per. change	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/5/27	# 720	change to ac 10	DONE ON B64610					J 11/5/27

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1X ϕ M-f 11/05/30

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:50
320 OF
12:20

1X ϕ M-f 11/05/30

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BL 11-6-31

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 BR 11-6-1

280

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/R ☐ Sikaflex-291 ☒ M/L 6415
Sikaflex expire date: ☐ 12-01.

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4
Batch: 117863.

1 BR 11-6-1.

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

300

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

310

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PPA 6.4580

W/O:		WORK ORDER CHANGES					
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Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/2
MF
11-06-02

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-151

Parent Item Name. Replacement Skidtube



Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured

No

Each

9.0000

1

1



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

9

62684

9

Each

23.0000

D3286-1

Manufactured

No



Doubler

Location

Loc Qty

Loc Code

ST050

23

52844

23

Each

57.0000

D2647

Manufactured

No



Cap

Location

Loc Qty

Loc Code

FP

57

55352

57

Each

425.0000

CR3212-4-04

Purchased

No



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

425

112314

25

113749

200

115698

200

116471 (52)

① 11-5-3

② 11-5-4

BE 11/05/04

11.05.10

W/O:		WORK ORDER CHANGES					
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Work Order ID: 646115

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No

1364781

Each 0.0000

1



Web

D2649 Manufactured No

Each 53.0000

19

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

53

58545

2

60652

4

61496

2

62889

13

63359

32

D3286-3 Manufactured No

Each 7.0000

2

2



Spacer

Location

Loc Qty

Loc Code

LG

7

46643

7

CCR264SS3-3 Purchased No

Each 330.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

330

112314

4

113539

44

113973

282

117086

2

BE 11/05/10

Thursday, December 09, 2010 10:19:03 AM

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 64611

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

Each

1,873.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1873

110153

35

111359

5

112314

2

114436

448

114450

37

114859

1346

D2680-041

Manufactured

No

Each

20.0000

1



Nut Plate

Location

Loc Qty

Loc Code

ST021

20

55366

20

D3805-041

Manufactured

No

Each

0.0000

1



Wearplate Assembly Fwd, Low Gear

D3805-045

Manufactured

No

Each

0.0000

1



Wearplate Assembly Aft, Low Gear

AN3-37A

Purchased

No

Each

654.0000

7

7



Bolt

Location

Loc Qty

Loc Code

ST353

654

105425

154

111668

500

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:19:03 AM

Work Order ID: 64611

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtable

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased

No

Each

8.0000

7

7



Washer

Location

Loc Qty

Loc Code

ST 116583

6

107715

6

ST335

2

105792

2

7. BL 11-6-1

MS21042L3

Purchased

No

Each

1,213.000

7

7



Nut

Location

Loc Qty

Loc Code

ST300 116540

1213

114784

217

115835

996

7. BL 11-6-1

D3873-1

Manufactured

No

Each

81.0000

14

14



Bushing

Location

Loc Qty

Loc Code

ST092 64760

70

62197

40

63314

30

ST093

11

57615

11

14. BL 11-6-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:19:03 AM

Page 5

Work Order ID: 64611

Parent Item: D206-642-151

Parent Item Name: Replacement Skid: be

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD416

NAS1149D0463J

Purchased

No

Each

30.0000

1

1



Washer

Location

Loc Qty

Loc Code

ST300 117291

24

113288

24

ST356

6

115622

6

D2651-1

Manufactured

No

Each

539.0000

6

6



Plug

Location

Loc Qty

Loc Code

FP 67760

217

51530

152

62638

65

fpa

322

53349

205

57869

117

D2651-3

Manufactured

No

Each

432.0000

6

6



O-Ring

Location

Loc Qty

Loc Code

FP

432

46114

12

61962

420

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:19:04 AM

Page 6

Work Order ID: 64611



Parent Item: D206-642-151



Parent Item Name: Replacement Skidplate

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

Each

95.0000

1

1



Screw

Location

Loc Qty

Loc Code

ST292

95

109061

5

115460 ✓

90

D2646

Manufactured

No

Each

76.0000

1

1



Aft Cap

Location

Loc Qty

Loc Code

FP-4

17

57332

17

FP6

5

52663

3

63633

2

Return 2010

54

62678 ✓

54

MS27039-1-08

Purchased

No

Each

1,364.000

2

2



Screw

Location

Loc Qty

Loc Code

ST291

1364

107378

1

108077

37

110835 ✓

455

115108

871

2 BR

11-6-1

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:19:04 AM

Page 7

Work Order ID: 64611

Parent Item: D206-642-151

Parent Item Name: Replacement Skid Plate

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

NAS1149D0332J

Purchased

No

Each

38.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST182

38

104885

38

117291

2. BK 11-6-1.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

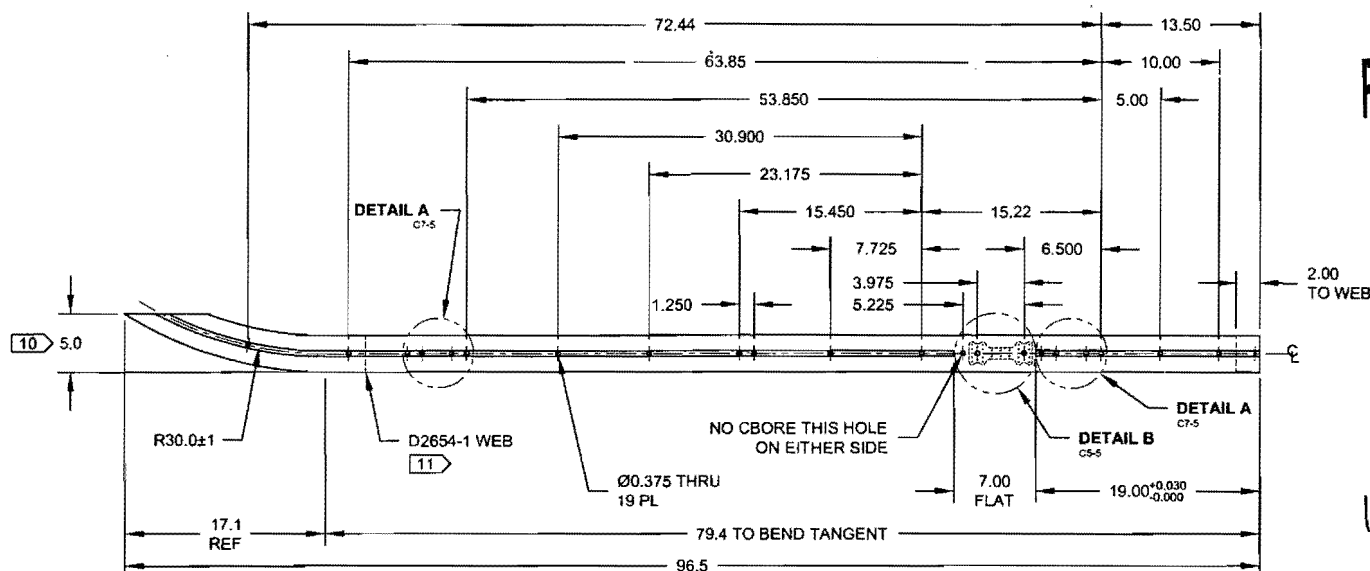
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44611

B/10-12-14

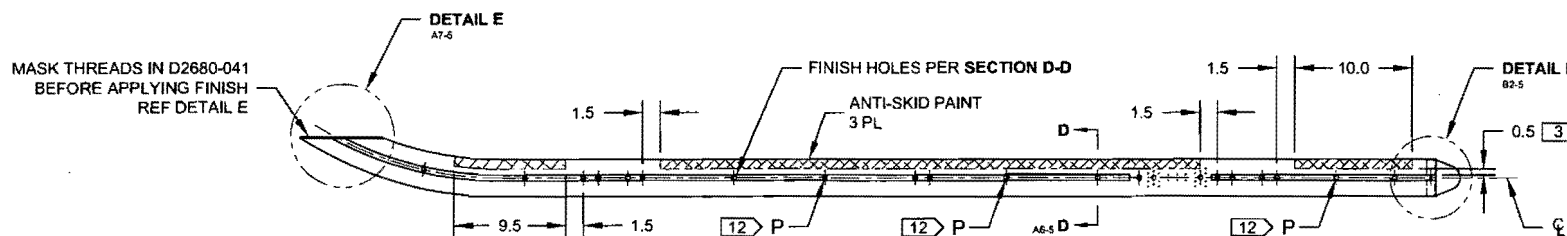
RELEASED
U 09.07.07
per ECN 09-590

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>91</i>	DART AEROSPACE USA, INC	
DRAWN	<i>1</i>	PORT HADLOCK, WA	
CHECKED	<i>2</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>3</i>	D3804	SHEET 1 OF 5
APPROVED	<i>4</i>	TITLE	SCALE
DE APPR.	<i>5</i>	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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09.03.03



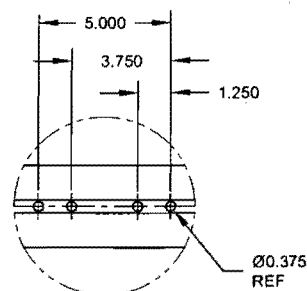
D3804-041 BENDING/DRILLING DETAIL



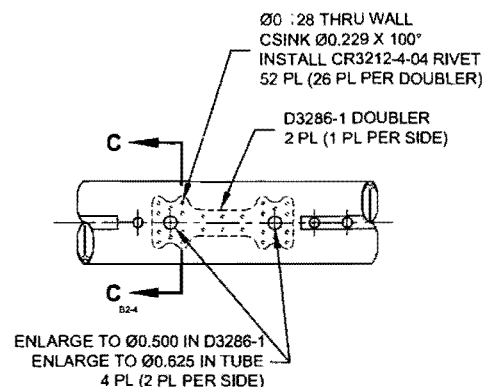
D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	Q	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 2 OF 5
APPROVED	49	TITLE	SCALE
DE APPR.	J	SKIDTUBE ASSEMBLY, 206A/B	NTS
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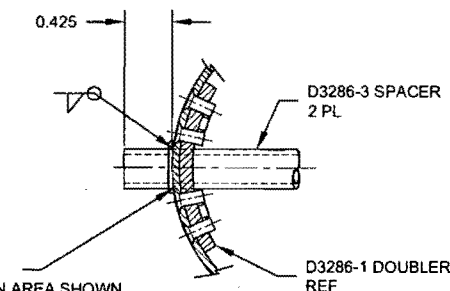
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UP 09.03.03



DETAIL A D6-2
SCALE NONE C2-2
D6-3
C2-3

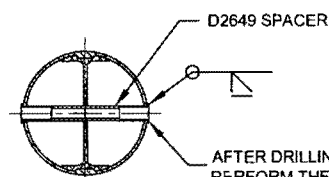


DETAIL B C3-2
SCALE NONE C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE

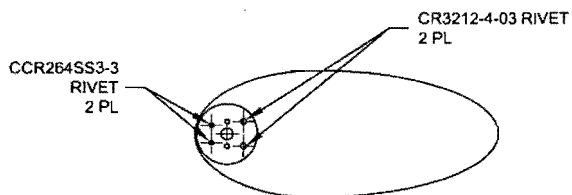


SECTION D-D A4-2
FOR Ø0.375 HOLES ONLY A4-3
SCALE NONE

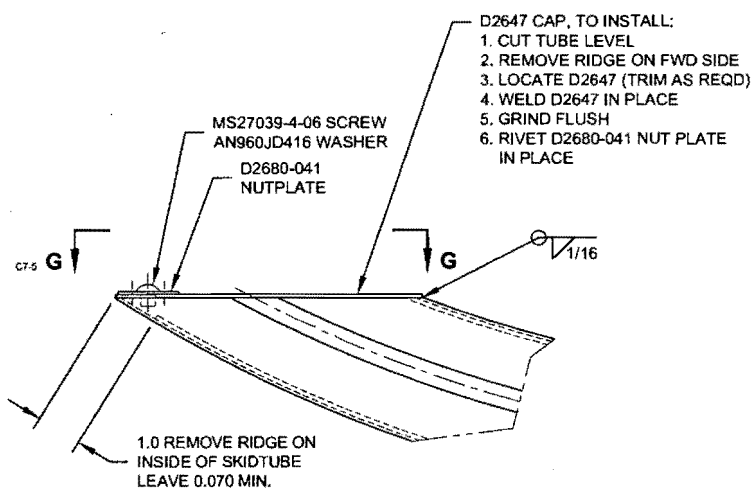
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

DESIGN	9	DART AEROSPACE USA, INC	
DRAWN	9	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	9	D3804	SHEET 4 OF 5
APPROVED	9	TITLE	SCALE
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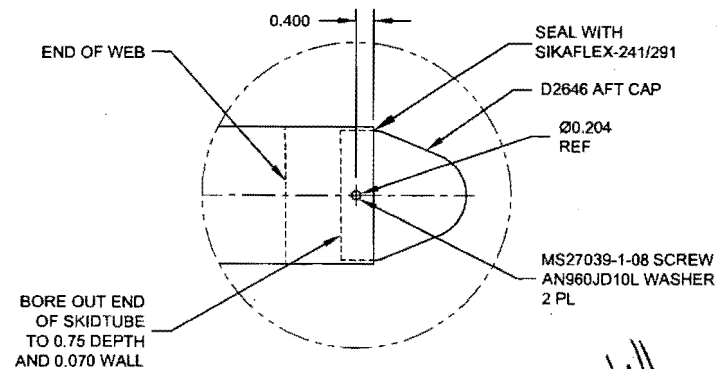
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VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
APPROVED	97	TITLE	SCALE
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NO. 252

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 66358
Part number: D206 642 541
Description: 206
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Burns Date of Test Coupon 11-05-09

Welder Barclay Elliott Date of Test Coupon 11-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

